

Shop -30/04 /test

Dart Aerospace Ltd.

Date: Wednesday, 3/26/2008 9:33:38 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services				Drawing Name	: "T" HANDLE ASSEMBLY	
Job Number	38145				Part Number	: D2282041	
Estimate Number	11179				Drawing Number	: D2282 REV E	
P.O. Number	:				Project Number	: N/A	
This Issue	: 3/26/2008	S.O. No.	:		Drawing Revision	: E	
Prsht Rev.	: NC				Material	:	
First Issue	: //	Type	: LARGE FAB ASSY		Due Date	: 4/1/2008	
Previous Run	: 37805A				Qty:	10 Um: Each	
Written By	:						
Checked & Approved By	JD 08.3.27						
Comment	: Est Rev:A	Removed from 9 Digit	05-12-02	JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D22823	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Pick:	
		Qty Part Number	Description Batch
		1 D2282-3	Handle tube B335472 → 42 ✓
			10 08/04/15
2.0	D22825	Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		Pick:	
		Qty Part Number	Description Batch
		1 D2282-5	Handle tube B36774 → 42 ✓
			10 08/04/15
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Weld as per D2282-041 'T' Handle Assembly	
		Grind chamfers and ensure full penetration.	
		A/R ER316L SS Filling Rod 1107051	
		Dwg Rev: E	
			10 08/04/17
4.0	QC9	VISUAL WELDING INSPECTION	
		Comment: VISUAL WELDING INSPECTION	
			10 08/04/17 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:33:39 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 38145

Part Number: D2282041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

08/01/21 08/04/21

(42)

Tumble

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/21 (42) coates

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

SP 08/04/21

(42)

8.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/2021

Job Completion



a 08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

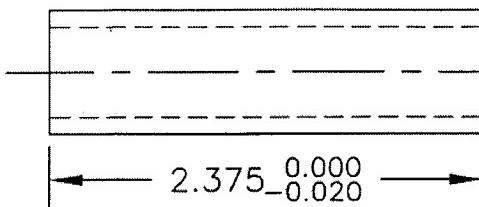
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

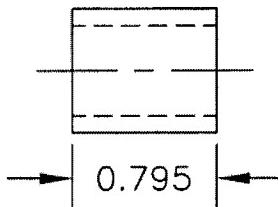
NOTE: Date & initial all entries

DART

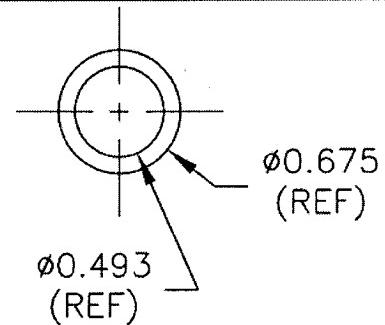
DESIGN BW	DRAWN BY <i>TPZ</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DP</i>	APPROVED <i>DP</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1	
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



D2282-3



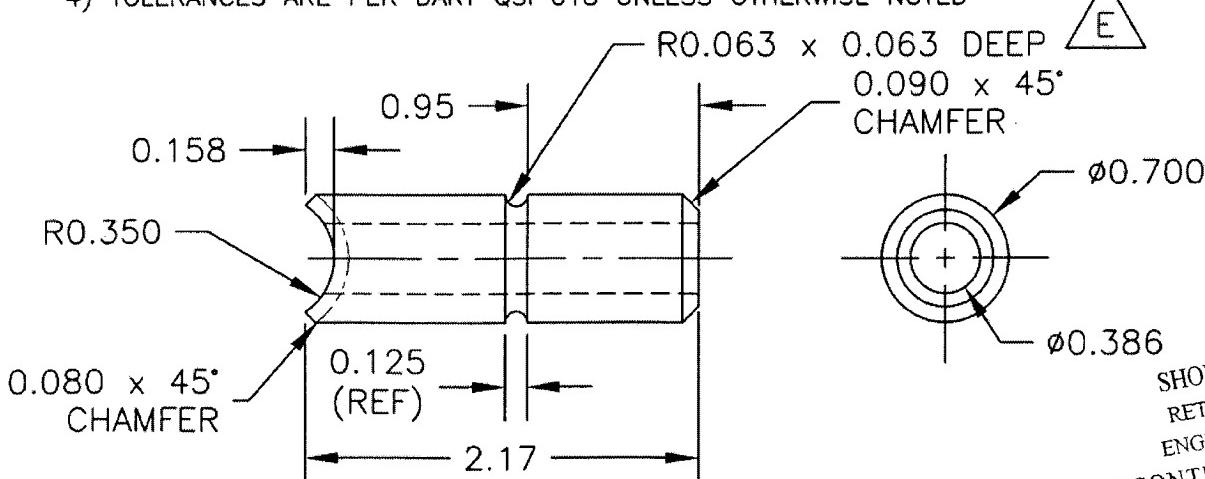
D D2282-7



Ø0.675
(REF)
Ø0.493
(REF)

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

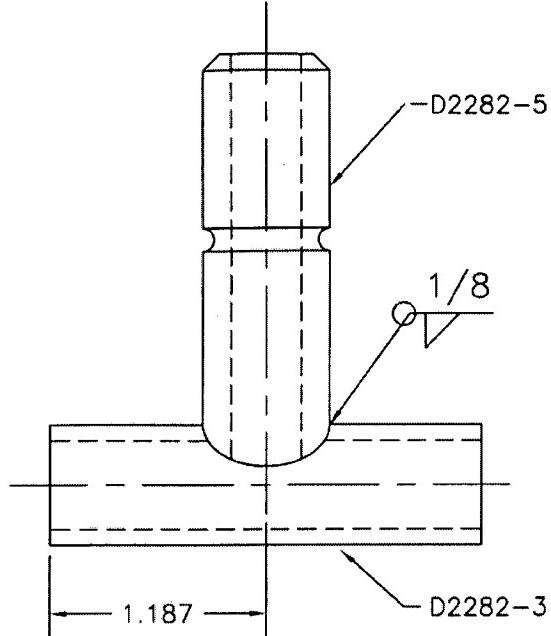
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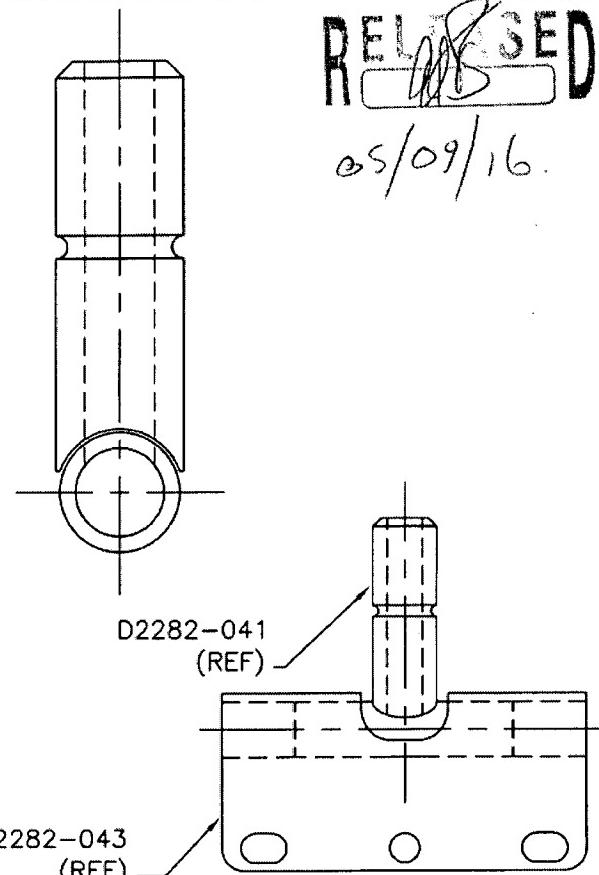
WORK ORDER
NO. 38145

DART

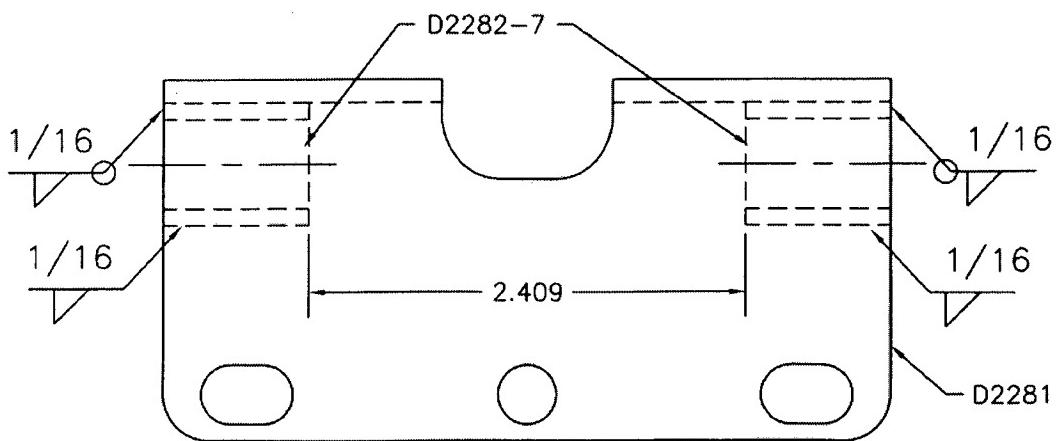
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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NO. *38145*